

Work Order ID 96993

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Item ID: D4092-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step Assembly
 Start Date: 2/13/13 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/22/13 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	B								
100	Pick Kit	0.00				<i>2x</i>			<i>EP 13/02/28</i>
100									
Packaging	Memo	0.00							
Packaging									
110		0.00				<i>2x</i>			<i>EP 13/02/28</i>
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00				<i>2</i>			
120									
QC	Memo	0.00							
Quality Control									

27
13 2 28

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Item ID: D4092-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step Assembly
 Start Date: 2/13/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/22/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2x
 13-2-28
 13/3/4
 MK
 B-3-01

Picklist Print

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Work Order ID: 96993

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/13/13

Required Date: 2/22/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-0 Maintenance Step		Manufactured	No			100	Each	6.0000	2	4		2/13/28	

Location	Loc Qty	Loc Code
GA	1	
77852	1	
st200	4	
93197	4	
ST241A	1	
74303	1	

B 95735 (4)

D4093-1
Bracket

Manufactured No 100 Each 5.0000 1 2

Location	Loc Qty	Loc Code
ST201	5	
93754	5	

D4093-3
Bracket

Manufactured No 100 Each 8.0000 1 2

Location	Loc Qty	Loc Code
ST201	8	
93253	8	

D4093-5
Bracket

Manufactured No 100 Each 4.0000 2 4

Location	Loc Qty	Loc Code
ST093	4	
93724	4	

MS24694-S54
Screw

Purchased No 100 Each 80.0000 2 4

Location	Loc Qty	Loc Code
ST303	80	
123900	80	

Picklist Print

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Work Order ID: 96993

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/13/13

Required Date: 2/22/13

Start Qty: 2.00

Required Qty: 2.00

MS24694-S55

Screw

Purchased No

100 Each 159.0000 8 16

Location

Loc Qty

Loc Code

ST303

159

123758

9

124296

150

MS24694-S56

SCREW

Purchased No

100 Each 40.0000 2 4

Location

Loc Qty

Loc Code

ST303

40

121340

15

124040

25

NAS1149D03320

Washer

Purchased No

100 Each 1,145.0000 12 24

Location

Loc Qty

Loc Code

FP001

142

122973

142

ST294

1003

122973

1003

MS21042L3

Nut

Purchased No

100 Each 7,210.0000 12 24

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

414

122452

414

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

6525

123900

2525

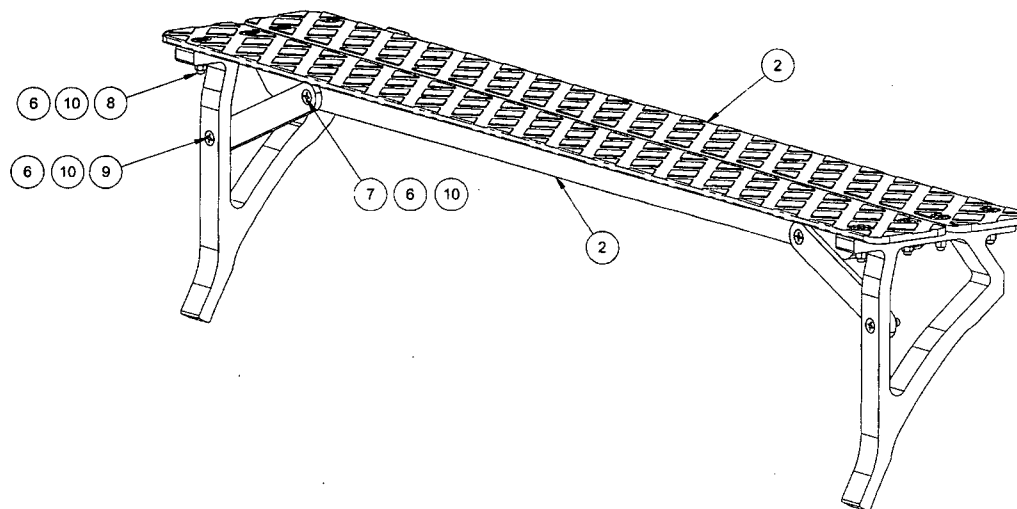
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4000

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Shop Packet Print

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D4092-041 MAINTENANCE STEP ASSEMBLY

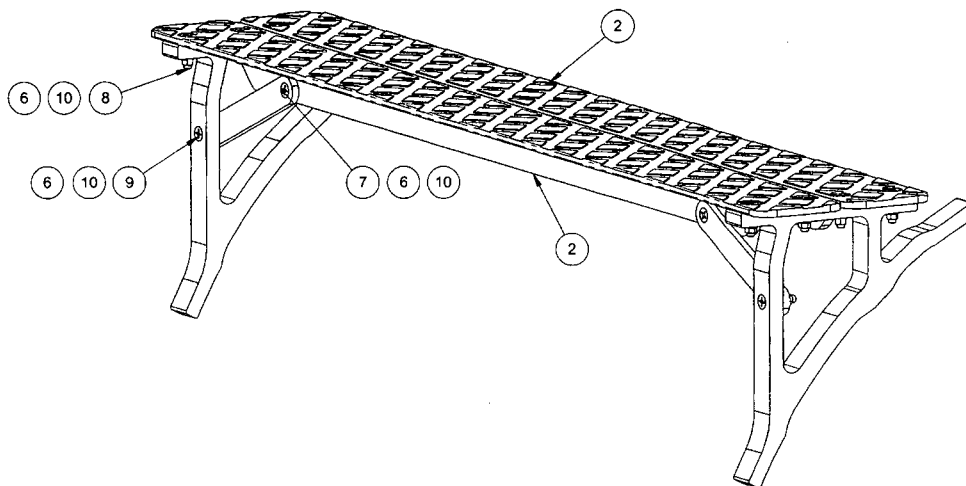


c/o 96993

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 1 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



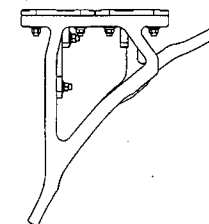
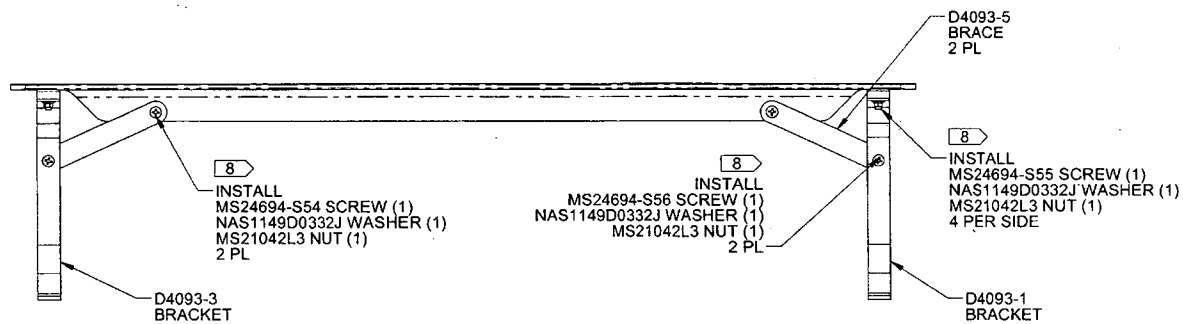
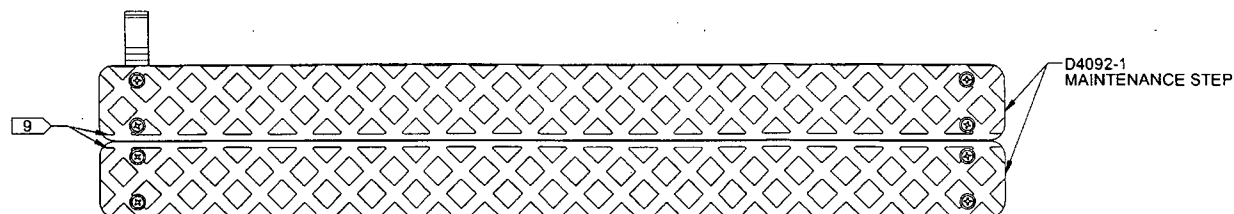
D4092-042 MAINTENANCE STEP ASSEMBLY



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22
JW

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 2 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
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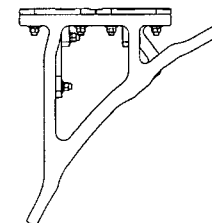
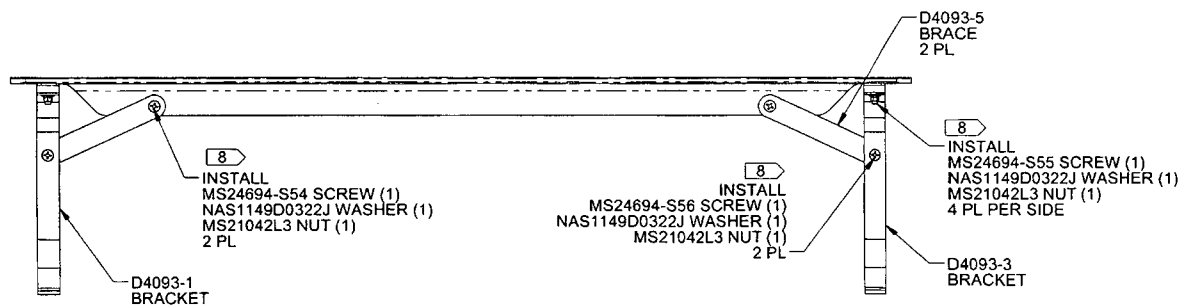
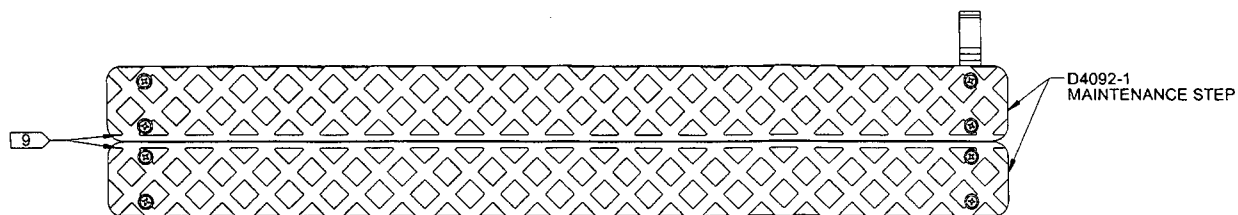
D4092-041/MAINTENANCE STEP/ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>RF</i>	D4092	SHEET 3 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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RELEASED
2011-09-22

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
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- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4092	SHEET 4 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	MAINTENANCE STEP ASS'Y	NTS
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